

Date: Wednesday, 5/16/2007 1:42:33 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 32411	
Estimate Number : 12740	
P.O. Number : <i>N/A</i>	Part Number : D353523
This Issue : 5/16/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3535 UNDER REVIEW
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : <i>AB</i>
Previous Run : 30760	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/31/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>26</i> Um: Each
Comment : Est Rev: A New Issue 07-02-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1.4296 sf(s)/Unit Total : 22.8732 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: *M101 873*

SAD 07/05/26

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: *AB*

Prog Rev: *AB*

2-Deburr if necessary

SAD 07/05/31 26
SB 07/06/20 26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/31 26

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SB 07-05-31 26

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158

3-Identify as D3535-23

MF 07-06-20 26
SB 07/06/21 26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 02/06/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:42:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32411

Part Number: D353523

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



count 26

Comment: INSPECT WORK TO CURRENT STEP

07/06/21

7.0

POWDER COATING

POWDER COATING



M101601



26X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-d 07/06/22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/06/25

9.0

PACKAGING 1

PACKAGING RESOURCE #1



26X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F-P-18

M-d 07/06/25

10.0

QC21

FINAL INSPECTION/W/O RELEASE



26

Comment: FINAL INSPECTION/W/O RELEASE

07/06/26

Job Completion



07/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

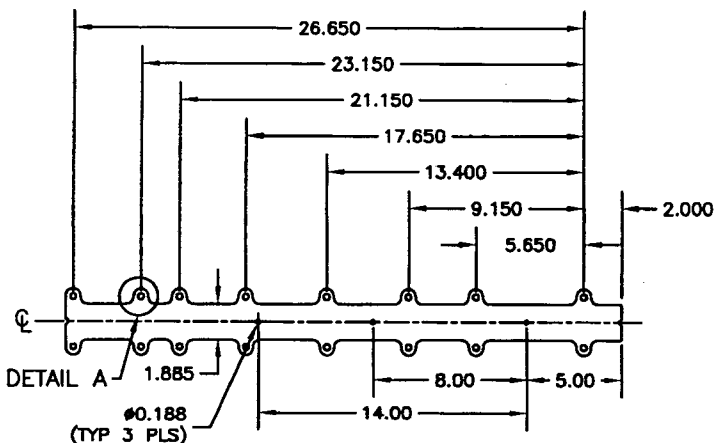
NOTE: Date & initial all entries

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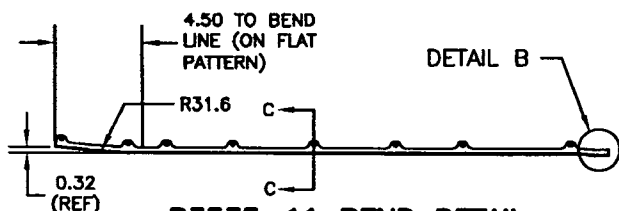
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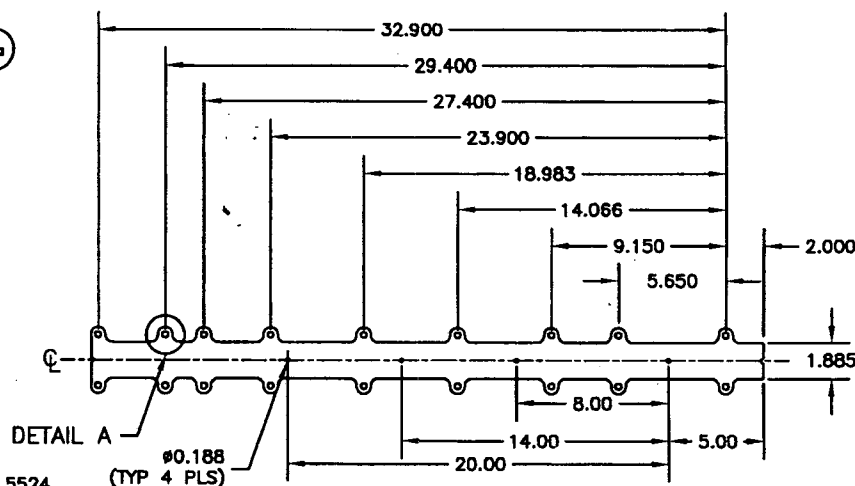
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		D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		



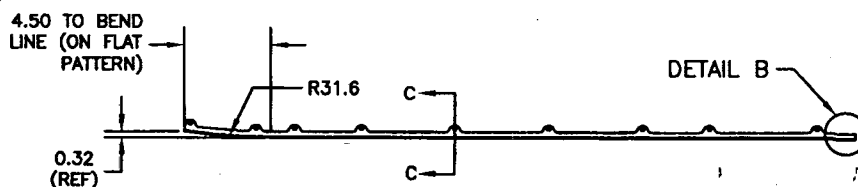
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

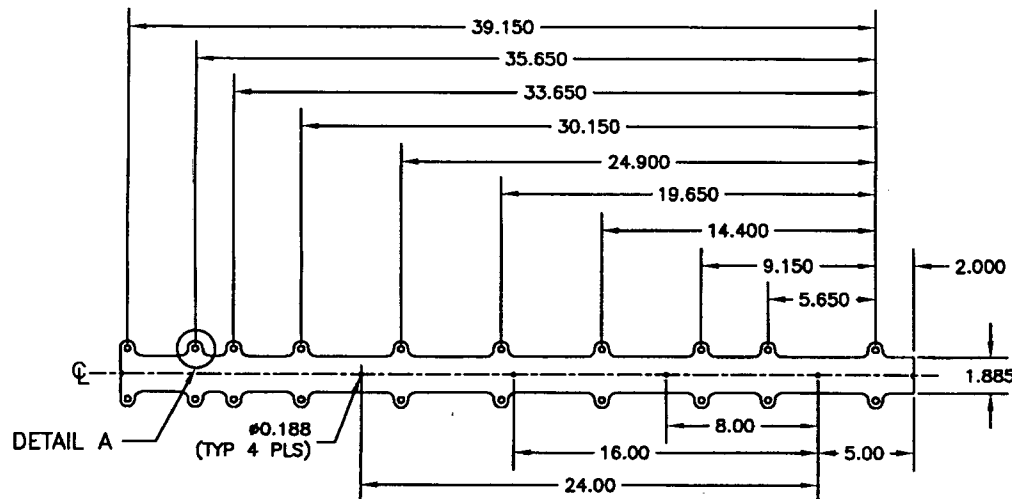
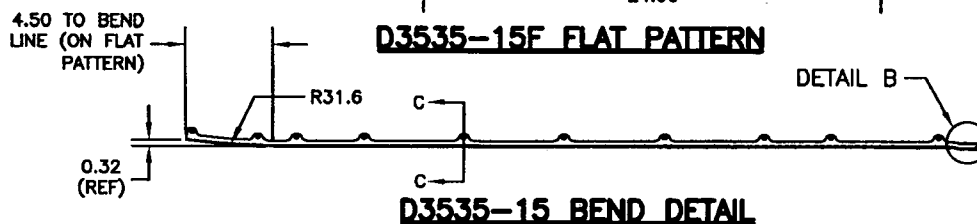
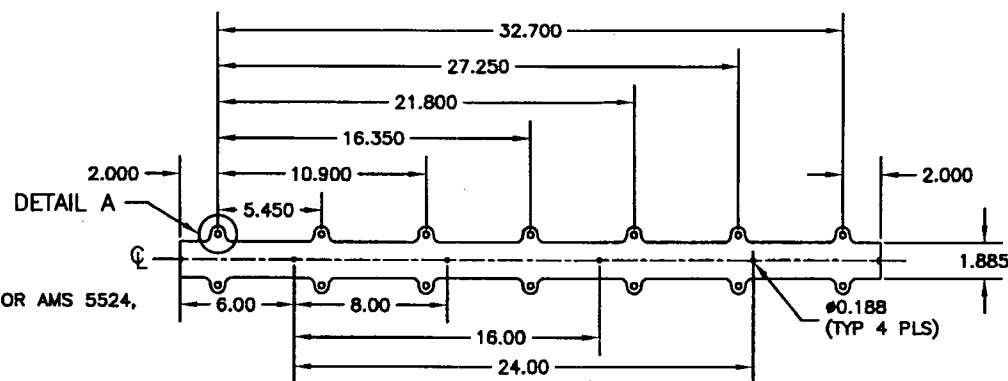
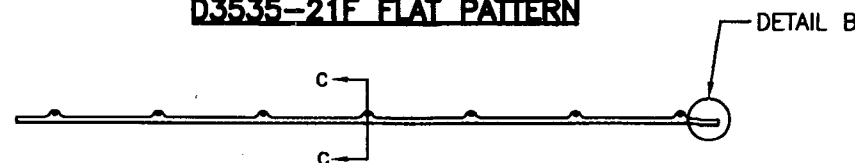
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DATE	TITLE	WEARSHOE	SCALE	
07.04.17			1:10	

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

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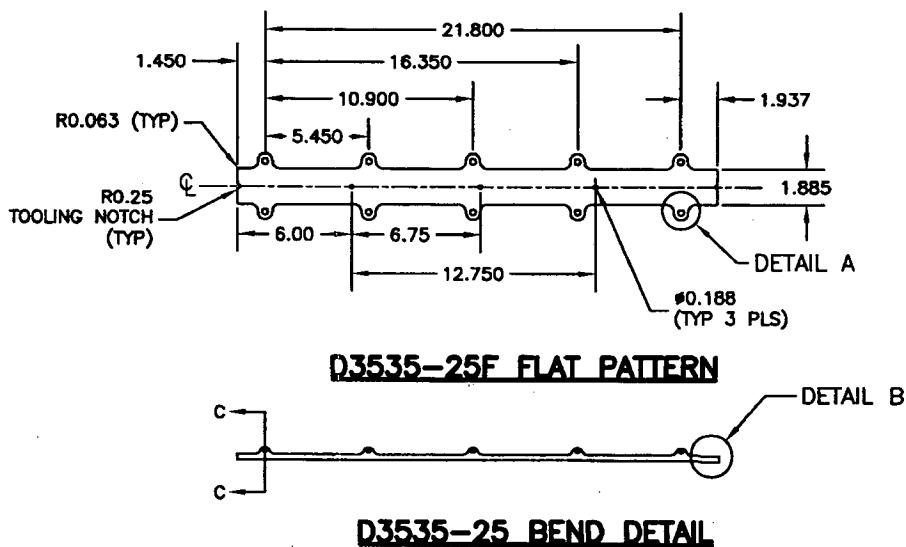
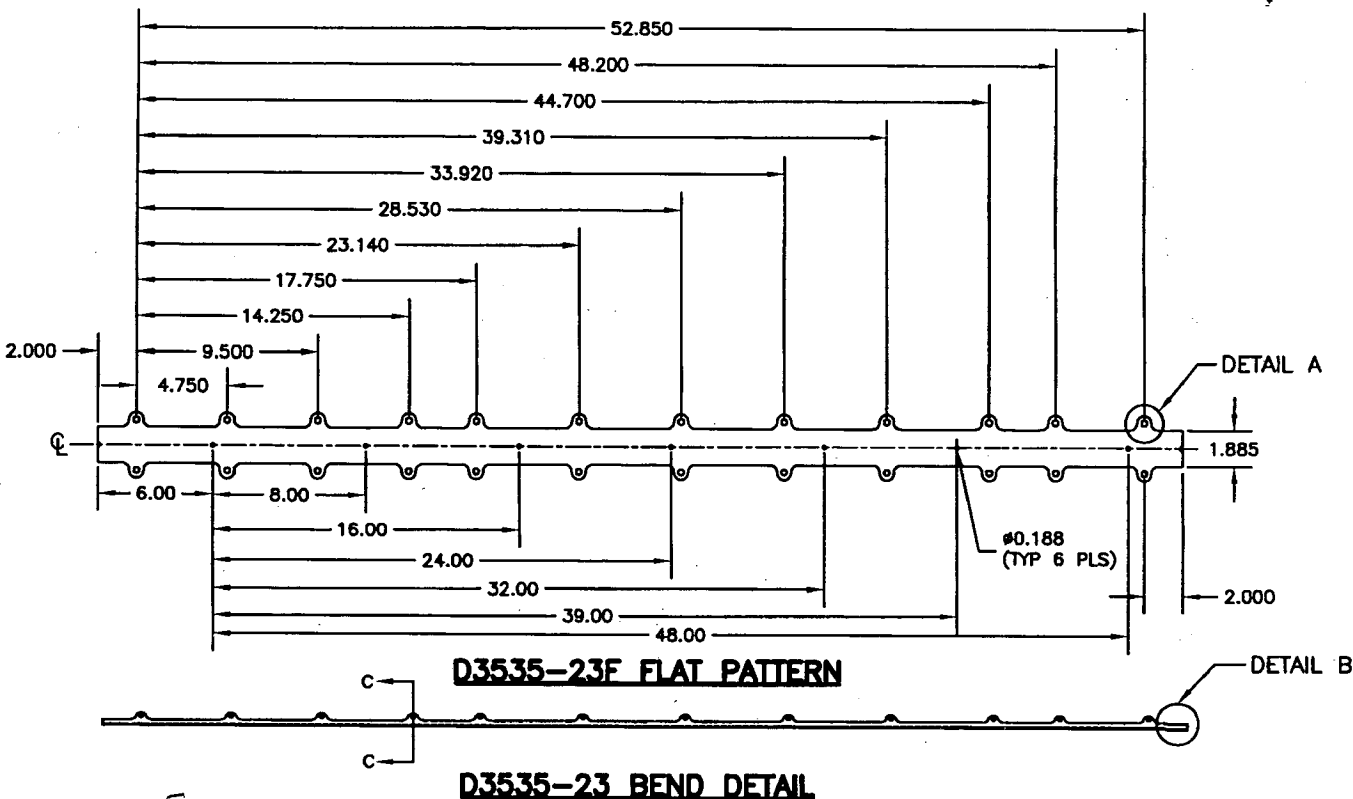
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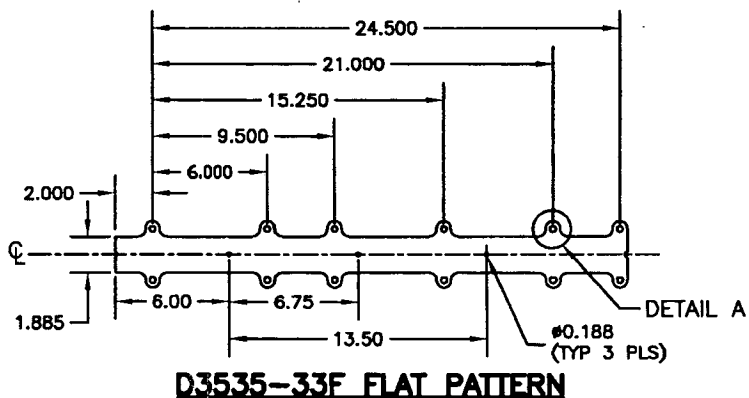
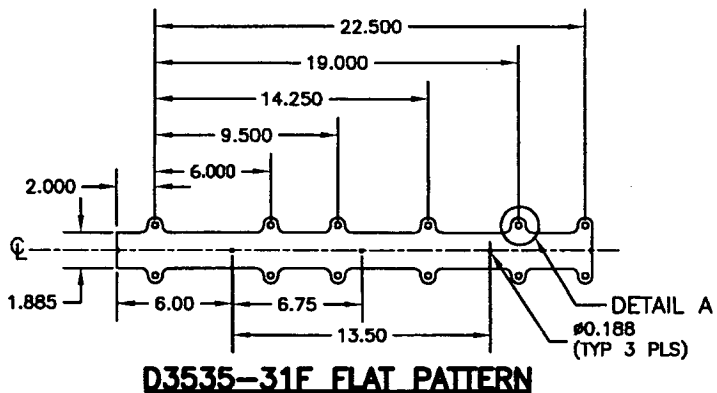
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		D3535
DATE	TITLE	SHEET 3 OF 7
07.04.17	WEARSHOE	SCALE 1:10

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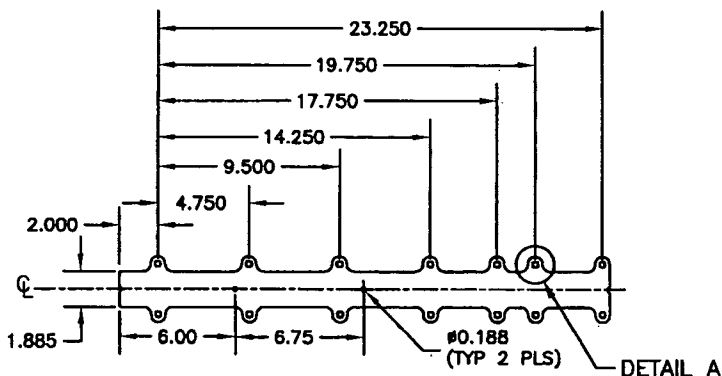
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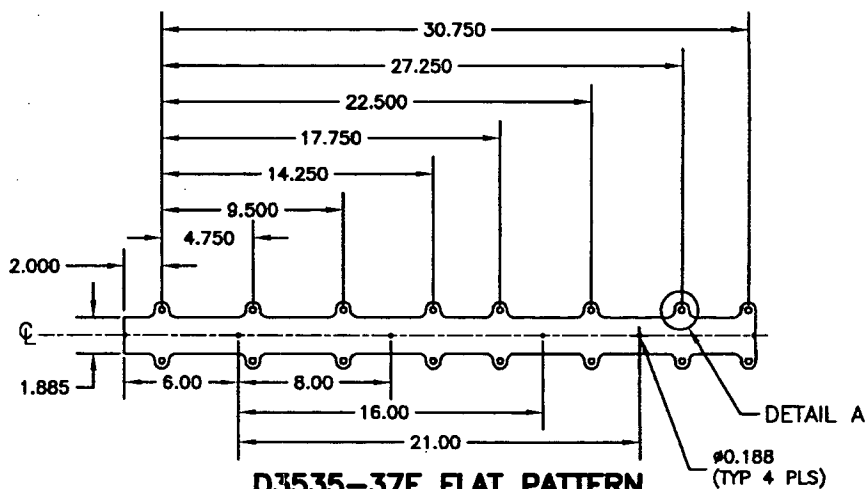
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		TITLE	WEARSHOE	SHEET 5 OF 7
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D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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NOTES

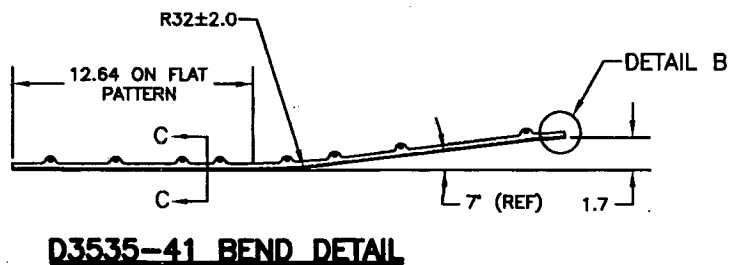
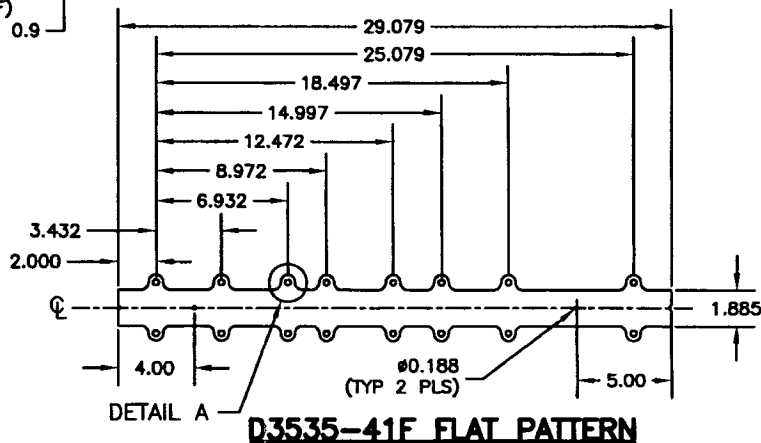
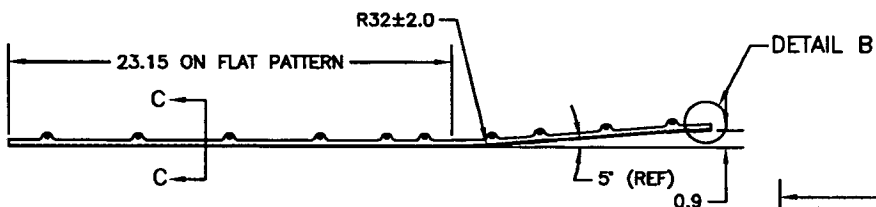
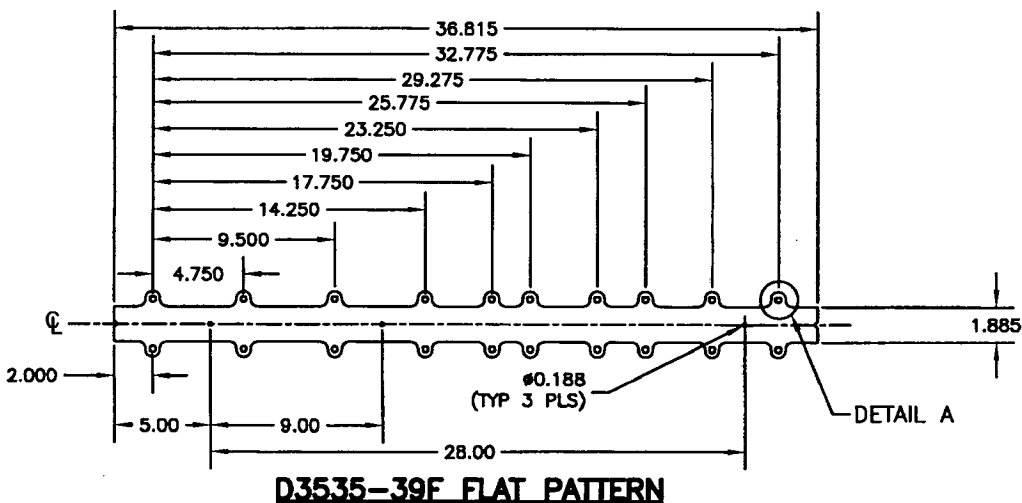
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		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



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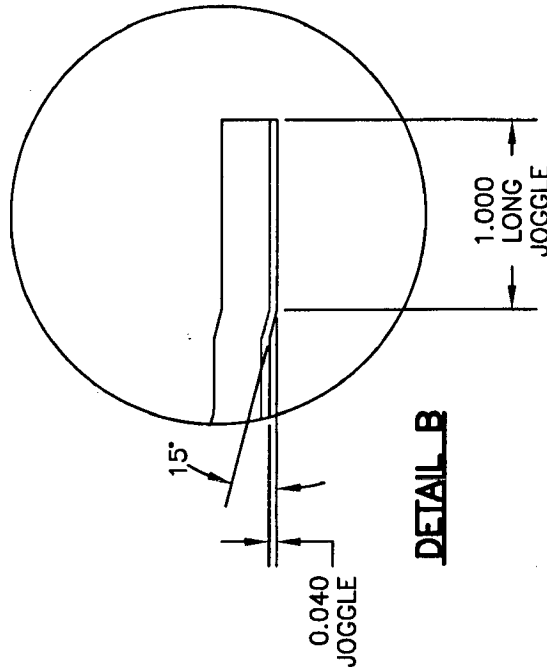
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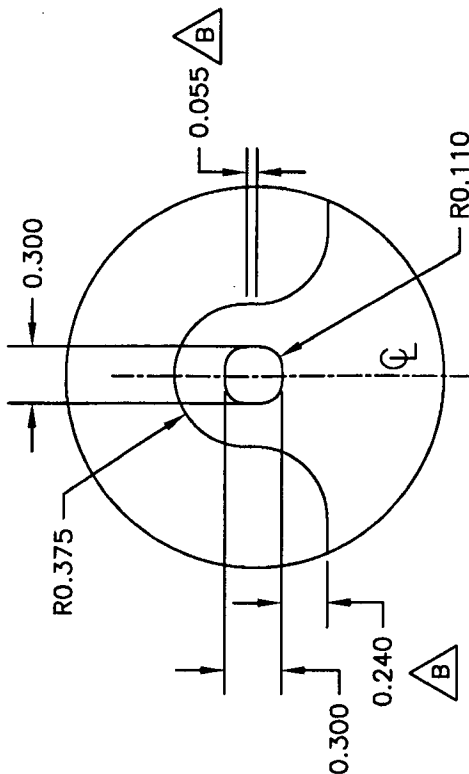
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DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

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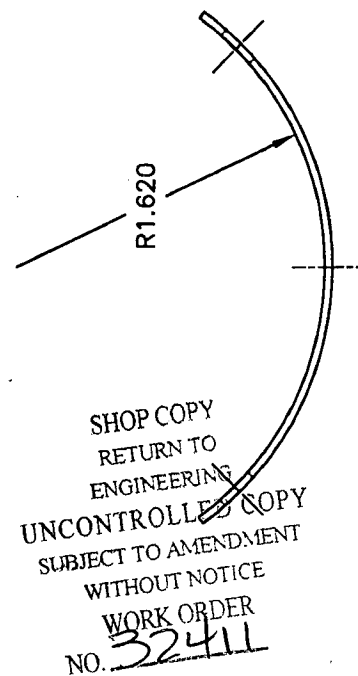
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DETAIL B



DETAIL A



SECTION C-C

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DART AEROSPACE LTD		Work Order: 32411
Description: WEAR SHOE		Part Number: D35 35 23
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	52.850	+/- 0.010	52.850	✓		Vern M-T	
B	48.200	+/- 0.010	48.200	✓		Vern M-T	
C	44.700	+/- 0.010	44.700	✓		M-T	
D	39.310	+/- 0.010	39.310	✓		M-T	
E	33.920	+/- 0.010	33.920	✓		M-T	
F	28.530	+/- 0.010	28.530	✓		Vern / M-T	
G	23.140	+/- 0.010	23.140	✓		M-T	
H	17.750	+/- 0.010	17.750	✓		M-T	
I	14.250	+/- 0.010	14.250	✓		M-T	
J	9.500	+/- 0.010	9.500	✓		Vern	
K	4.750	+/- 0.010	4.753	✓		Vern	
L	2.000	+/- 0.010	2.000	✓		Vern	
M	6.00	+/- 0.030	6.00	✓		Vern	
N	8.00	+/- 0.030	8.61	✓		Vern	
O	16.00	+/- 0.030	16.61	✓		Vern / MT	
P	24.00	+/- 0.030	24.01	✓		Vern / MT	
Q	32.00	+/- 0.030	32.00	✓		Vern / M-T	
R	39.00	+/- 0.030	39.00	✓		Vern / M-T	
S	48.00	+/- 0.030	48.00	✓		Vern / M-T	
T	1.885	+/- 0.010	1.891	✓		Vern	
U	0.300	+/- 0.010	0.300	✓		Vern	
V	0.300	+/- 0.010	0.297	✓		Vern	
W	0.033	+/- 0.010	0.036	✓		Vern	
X							
Y							

Measured by: <i>SAD</i>	Audited by: <i>SC</i>	Prototype Approval:	N/A
Date: 07/05/21	Date: 07.05.21	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	